

Work Order ID 65573

January 20, 2011 9:14:02 AM



Page 1

Item ID:	D3536-35	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	1/20/11	Start Qty: 6.00		Cust Item ID:		
Required Date:	2/04/11	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>1/10/12</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3536 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								

1811-1-27

(12)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

1811-1-27

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

1811-1-27

(+12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65573

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Page 2

Item ID: D3536-35

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 1/20/11

Start Qty: 6.00



Cust Item ID:

Required Date: 2/04/11

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *FP*

0.00

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

1/21/11 12

1/01/28
MF
11-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65573

Parent Item: D3536-35

Parent Item Name: Gasket



Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	321.3220	0.6197	4.131333	8.2		
NEOPRENE SHEET 0.063											1811-1-27		

Location

Loc Qty

Loc Code

MAT

321.322

115500

74.522

115916

246.8

115916

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	65573
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	X		T B01	
19.75	+/-0.030	19.75	X		T	
17.75	+/-0.030	17.75	X		T	
14.25	+/-0.030	14.25	X		T	
9.50	+/-0.030	9.50	X		T	
4.75	+/-0.030	4.75	X		T	
2.00	+/-0.030	2.00	X		V B02	
6.00	+/-0.030	6.00	X		V	
6.75	+/-0.030	6.75	X		V	
0.30	+/-0.030	.303	X		V	
0.30	+/-0.030	.303	X		V	
1.89	+/-0.030	1.888	X		V	
Ø0.19	+0.005/-0.001	.193	X		V	
0.063	+/-0.010	.063	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-1-27	Date: 11/01/27	Date:	N/A

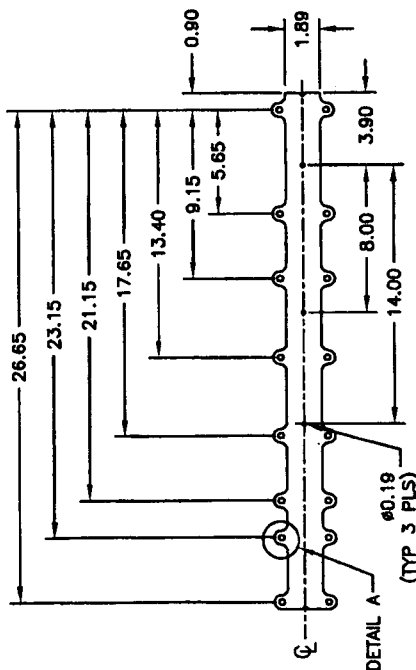
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	



DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10
A	06.10.25	NEW ISSUE	

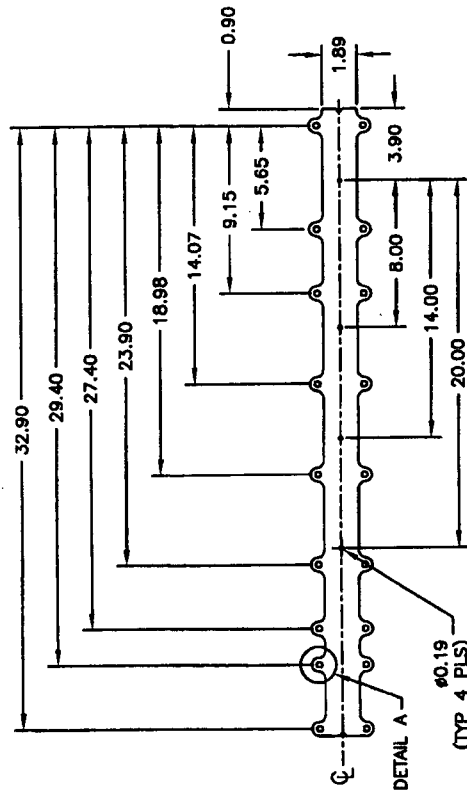
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D3536-11 GASKET

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WORK ORDER
NO. 05573
CL 11/01/20



D3536-13 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK. 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

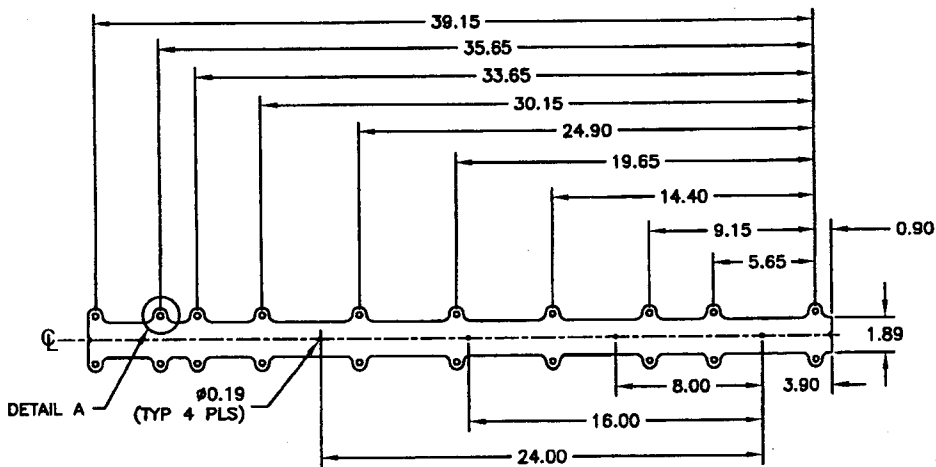
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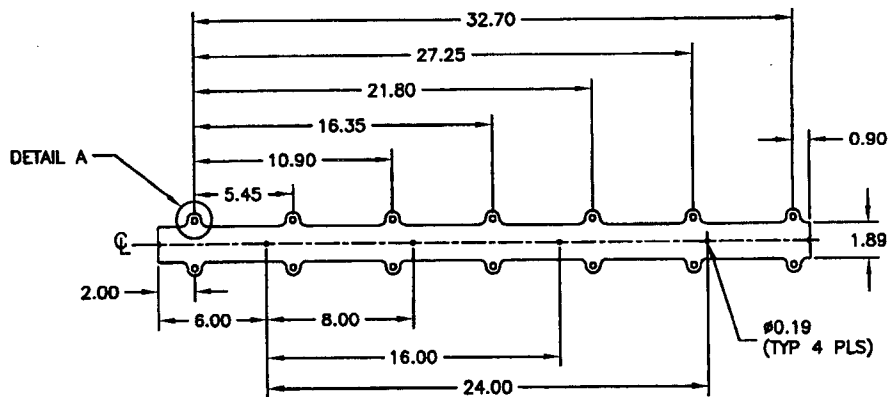
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		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

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D3536-15 GASKET



D3536-21 GASKET

NOTES

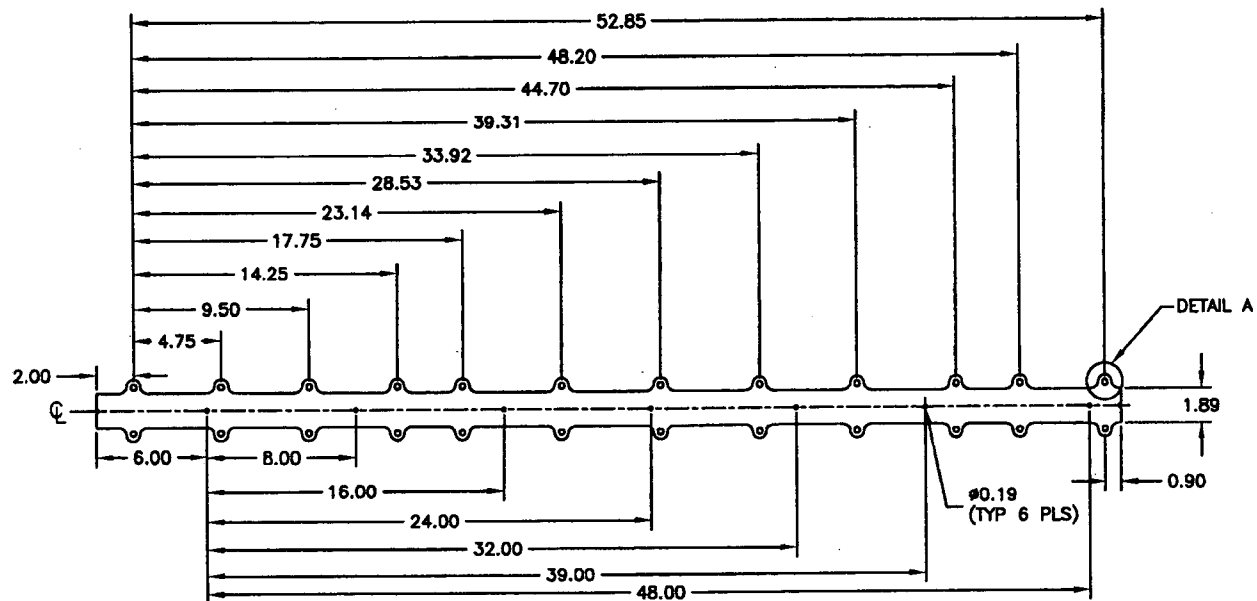
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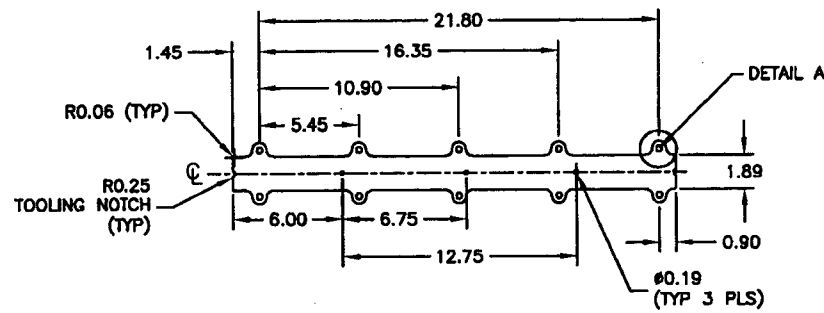
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		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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D3536-23 GASKET



D3536-25 GASKET

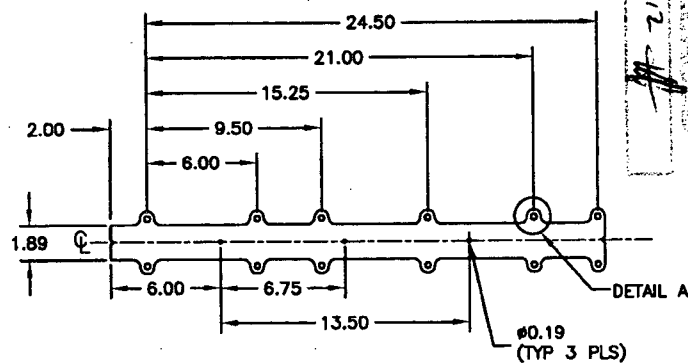
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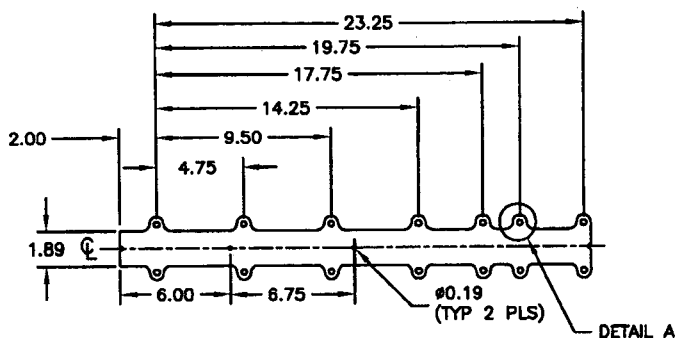
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		TITLE	GASKET	SHEET 4 OF 6
		SCALE	1:10	

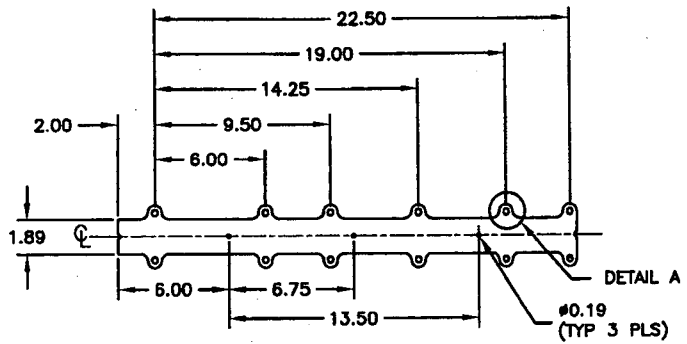
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

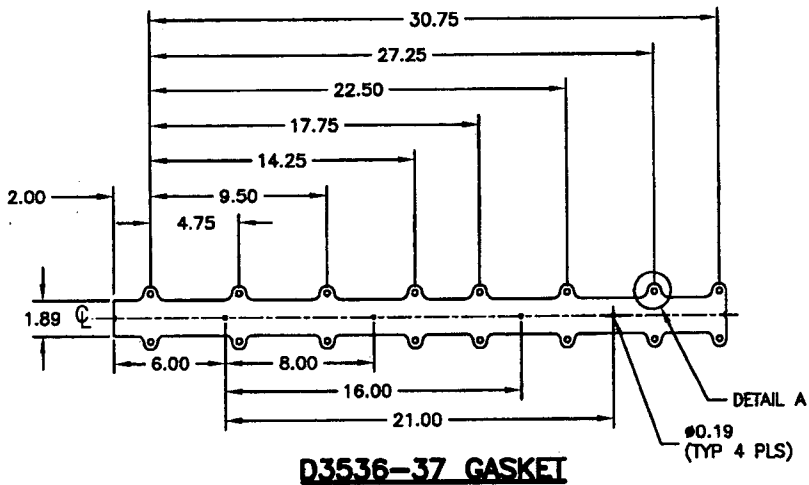
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		TITLE	GASKET	SHEET 5 OF 6
		SCALE	1:10	

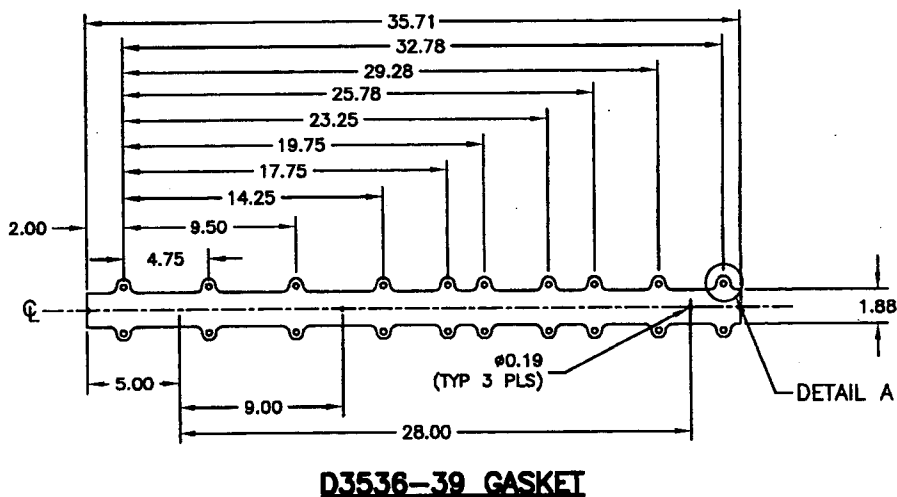
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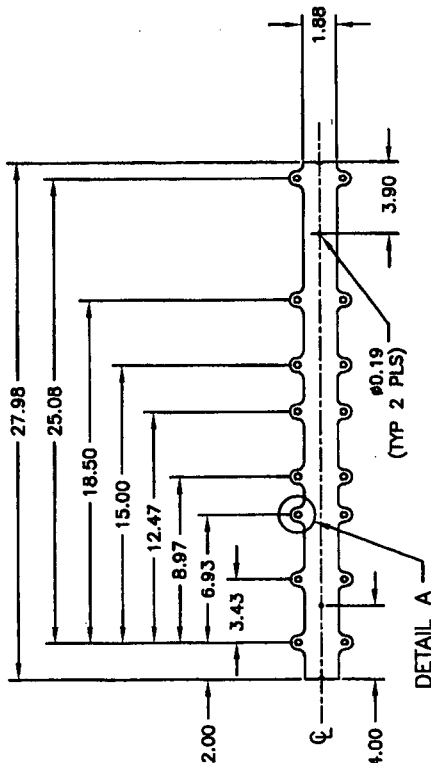
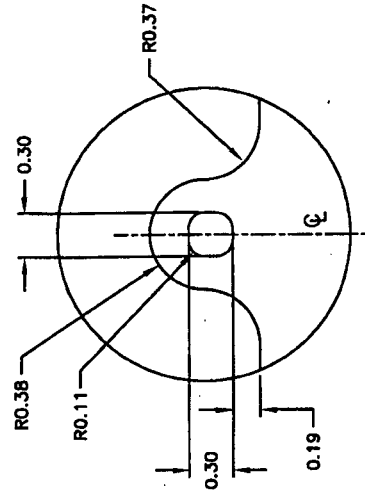
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DETAIL A



D3536-41 GASKET

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